

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028980**Date Inspected:** 07-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA performed observation of excavation of Electroslag Weld (ESW) designated as ESW T, Face A. Excavation was performed at location (Y= 3600mm~4000mm).

Recorded observations at depth:

-20mm depth

One (1) indication observed.

(Transverse)

Y= 3725mm

L= 5mm

-24mm depth

Two (2) indications observed.

(Transverse)

Y= 3725mm

L= 10mm

(Longitudinal)

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Y= 3815mm

L= 18mm

-25mm depth

One (1) indication observed.

(Longitudinal)

Y= 3815mm

L= 15mm

-26mm depth

Two (2) indications observed.

(Longitudinal)

Y= 3800mm

L= 30mm

(Longitudinal)

Y= 3790mm

L= 10mm

Per ABF instruction. Excavation rate has been increased to 3mm at a pass.

1mm pass will be reinstituted at discovery of planar type indication.

This QA performed observation of excavation of Electroslag Weld (ESW) designated as ESW T, Face B.

Excavation was performed at location (Y= 3250mm~3500mm).

-10mm depth.

No indications observed.

-11mm depth.

No indications observed.

-12mm depth.

No indications observed.

-13mm depth.

No indications observed.

-14mm depth.

No indications observed.

Excavation efforts have been halted due to end of shift.

Excavation was performed by ABF welding personnel using a mechanical grinder removing approximately 1-3mm at a time. This QA observed Quality Control Inspectors Andrew Keech and Jesse Kayabyab performing visual inspection and Magnetic Particle Testing (MT) of this excavation between passes. This QA performed

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

visual inspection and intermittent verification MT of this excavation between passes.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Conversation was relevant to excavation performed during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Clifford, William	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

---